

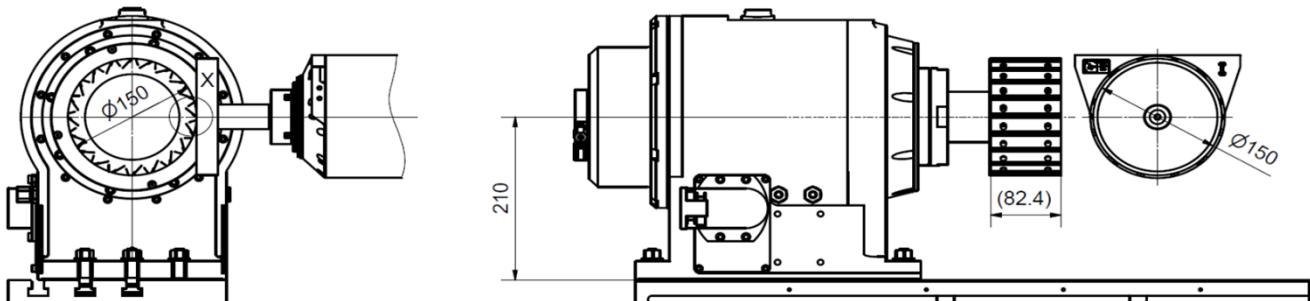
Planar Head Carbide Knife

A09-090

Width blank size 6mm, final knife size 5.5mm, material removal per side 0.25mm.

Process philosophy: two passes, one roughing and one finishing with a double-layer wheel, form 6A2.

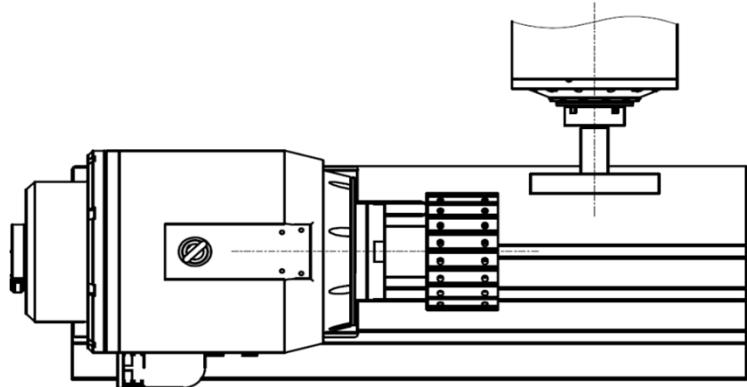
Roughing grain on the inside diameter, finishing grain on the outer diameter.



1. Cycletime for Production

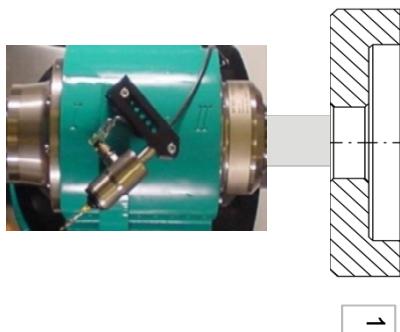
Workpiece:				
Length 82.4 mm, Width 5.5 mm, Thickness 1.1 mm Material carbide				
Operations				
Rough Clr	Finish Clr	Manual Handling	Sticking	
Feed [mm/Min]	600	600		400
Power [kW]	4	2		1
Cutting speed [m/s]	22	22		22
Used wheels	1	1		
Grinding time [s]	17	17	3	1
Total cycle time	00:38			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1 6A2 Ø150 D126 / D46



3. Machine and Software Requirements

Machines: **norma NGC**

Coolant: Emulsion, pressure 11 bar

Control: Fanuc 35i

Software: Quinto 5

Accessories: Multiposition Clamping

Responsible engineer: MAM, 13.01.16

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